

Work Order ID 161766

Tuesday, May 23, 2017 9:40:19 AM

161766

Page 1

Item ID: D2066

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 6/1/2017 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/9/2017 Req'd Qty: 2.00 ***2***

Customer:

Reference:

DAS

Approvals: Process Plan: 21 Date: MAY 24 2017 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2066	Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.85

Small Fab

1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube
(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

4-Bend per Dwg D2066

5-Drill using DT9034

2 _____ MLC
17-8-17

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.04

Quality Control

2 _____ DAS
38
9-89

AUG 17 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: 57385	0.00			DAS 6 9-89	2		AUG 2 1 2017	nl
120									
Packaging	Memo	0.02							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.20							
Quality Control									

UM 17/8/21DAS
21
9-89

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Picklist Print

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Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 6/1/2017

Required Date: 6/9/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D 02.03.18 Added pick list NG
IPP E 07.10.03 removed p/c EC verified by: DD
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2052 *D2052* Bracket		Manufactured	No			100	Each	11.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		11							
					146603	1							
					<u>153495</u>	10							
D2054 *D2054* Bushing - Delrin		Manufactured	No			100	Each	17.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		17							
					<u>155531</u>	17							
D2055 *D2055* Clamp		Manufactured	No			100	Each	8.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		8							
					<u>105730</u>	8							
D2056 *D2056* Bell Crank Assembly		Manufactured	No			100	Each	4.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		4							
					<u>147595</u>	4							

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Parent Item Name: Arm

Start Date: 6/1/2017

Required Date: 6/9/2017

Start Qty: 2.00

Required Qty: 2.00

M304TR0.500W.049

Purchased

No

120

f

41.2542

2.386

5.023158

M304TR0 500W 049

304 RD Tube .500 x .049W

**

MC

17-8-17

Location

Loc Qty

Loc Code

GA002

41.254158

M136846

1.17

M137091

1.53

M137169

9.179158

M137286

9.375

M137415

20

5.03

** not pull*

MS21042L3

Purchased

No

100

Each

1,931.000

2

4

MS21042L 3

Nut

**

MC

17-8-17

Location

Loc Qty

Loc Code

CCK007

1000

m137495

1000

FP001

91

m135945

91

GA

460

m134360

102

M136665

358

ST303

380

m137321

380

4

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Required Qty: 2.00

MS27039-1-18

Purchased

No

100

Each

1,615.000

2

4

MS27039-1-18

**

Screw

MCC
17-8-17

Location

Loc Qty

Loc Code

GA

239

123522

39

124326

200

over006

1200

124326

1200

ST280

176

124326

176

NAS1149D0363J

Purchased

No

100

Each

1,770.000

4

8

NAS1149D0363.J

**

Washer

MCC
17-8-17

Location

Loc Qty

Loc Code

GA

13

m134055

13

ST260a

1400

m137587

1400

ST263

357

m137164

357

GA M137963

8

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